

Work Order ID 57872

Monday, April 19, 2010 3:31:32 PM



Page 1

Item ID: D205-778-011

Accept



Setup Start



Revision ID:

Item Name: Comfort Seat, LH/RH

Stop



Start Date: 4/19/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: CL

Date: 10/4/20 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
DSI 9508	A
IIN D205-778	Rev B

100



DOCUMENT CONTROL

DC

Document Control

Memo

0.00

for LL 10/05/05
per ECN 0570

Solaris
05

110



Pick Kit

0.00

Packaging

Packaging

Memo

0.00

10/05/05 C

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Required Date: 4/26/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC4- 100% Inspect kits for completeness

Set Up/
Run Hours

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

S.105/05

(6)

130



Packaging

Packaging

Packaging

0.00

Memo

16-5 SP

Identify and pack for shipping as per PPP D205-778-101

Location: C

PPP Rev: C

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/05/05 JJ

W WWS.06

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Picklist Print

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Parent Item: D205-778-011



Parent Item Name: Comfort Seat, LH/RH

Start Date: 4/19/2010

Required Date: 4/26/2010

Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD6L** 	NL	Purchased	No			110	Each	1,169.000	16.0000			

Warehouse

Location

Main Warehouse

ST347

Loc Qty

Loc Code

1169

5819

5519

1169



110

Each

0.0000 8.0000



M114598

10-5-2010

Purchased

No

Manufactured

No

Manufactured

No

Warehouse

Location

Main Warehouse

ST252A

Loc Qty

Loc Code

4



50655

4

Each

2.0000 1.0000

50655

Manufactured

No

Warehouse

Location

Main Warehouse

ST252A

Loc Qty

Loc Code

2



44543

2

50152

10-5-2010

D3755-041



Seat Cushion

S

lev C

SL

SL

SL

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Comments: IPP Rev:A 08-10-20 New Issue DD verified by:EC
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IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3756-041 X1 Cushion		Manufactured	No			110	Each	2.0000	1.0000		55153	

Warehouse

Location

Main Warehouse

ST252A

Loc QtyLoc Code

2

44544

2

D3758-041
X2
Clamp

Manufactured

No

110

Each

4.0000

2.0000



Warehouse

Location

Main Warehouse

ST086

Loc QtyLoc Code

4

46658

4

D3777-041
X2
Clamp

Manufactured

No

110

Each

24.0000

2.0000



Warehouse

Location

Main Warehouse

ST087

Loc QtyLoc Code

24

46659

24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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per DSI 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3800-3-200		Manufactured	No			110	f	188.0000	2.1053			

Hook and Loop Strip (2" Hard)

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST089	188
43367	113
56393	75

93367

Cut to length as per dwg

AN52510R8

X8

Purchased

No

110

Each

40.0000

8.0000



Screw

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST325	40
111274	40

111274

AN970-3

X8

Purchased

No

110

Each

72.0000

8.0000



Washers

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST349	72
113749	72

113749

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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per DS1 9508 DD 10.03-24 verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD10	X8	Purchased	No			110	Each	0.0000	8.0000		m114292	
Washer	NA61149D09630											
Nut	MS21042L3	X8	Purchased	No		100	Each	1,131.000	8.0000			1/16/13

Warehouse
Location

Main Warehouse

ST300	1131
113537	147
113644	984

Loc Qty

Loc Code

m113697

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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4.0 WEIGHT AND BALANCE

The following is the net weight increase associated with the modification kits.

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-778-011 Comfort Seat Kit, LH / RH	13.0 lb 5.9 kg	±22.0 in ±0.56 m	±286 in-lb ±3.3 m-kg	47.0 in 1.19 m	611 in-lb 7.0 m-kg

5.0 PARTS LIST

Qty	Part Number	Description
*1	D205-778-011	COMFORT SEAT KIT (FITS LH & RH)
1	D3752-1	SEAT FRAME
1	D3755-041	CUSHION
1	D3766-041	CUSHION
1	D3768-041	CLAMP ASSEMBLY
*2	D3758-1	CLAMP
*2	D2182B028	RUBBER CUSHION
*2	D3777-041	CLAMP ASSEMBLY
*2	D3777-1	CLAMP
*2	D2182B013	RUBBER CUSHION
1	D6800-3-200-060	HOOK STRIP
8	AN525-10R8	SCREW
8	AN970-3	WASHER
8	AN960JD10	WASHER
8	MS21042L3	NUT (OR MS21042-3)

* REFERENCE ONLY. PARTS ARE INCLUDED IN ASSEMBLY ABOVE.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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DART SERVICE-INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D205-778 REV. B
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D205-778 REV. 1
REF TCCA STC: SH08-37
REF FAA STC: SR02704NY
REF EASA STC: EASA.IM.R.S.01518

PURPOSE:

To provide instructions to allow the hook strip (ie. velcro) on the D3752-1 Seat Frame to be fastened with rivets.

CHANGE:

D205-778-011 Comfort Seat Kits at CHG 002 have rivets and washers that may be installed to fully secure the D3800-3-200-060 Hook Strip to the D3752-1 Seat Frame. The parts list of Installation Instructions IIN-D205-778 and Instructions for Continued Airworthiness ICA-D205-778 is amended as shown below. Installation of the rivets is optional.

PARTS LIST

QTY	Part Number	Description
-011		
X	D205-778-011	Comfort Seat Kit
8	BSP-42	Rivet (Add)
16	NAS1149DN616J	Washer (or AN960JD6L) (Add)

INSTALLATION INSTRUCTIONS

Install the BSP-42 rivets as detailed below, see Figure 1 of this service instruction as reference:

- 1) Ensure location of D3800-3-200-060 Hook Strip lines up with loop strip on seat cushions.
- 2) Drill D3752-1 Seat Frame using 9/64" (Ø0.141) drill in appropriate locations: ensure rivet location will not interfere (contact) with the OEM metal seat frame. Deburr hole.
- 3) Install each BSP-42 rivet with qty(2) NAS1149DN616J washers (one on either side of the plastic seat frame). It is acceptable to substitute longer/shorter BSP rivets or thicker NAS1149DN632J washers to ensure proper fit.

UPGRADE KIT

For D205-778-011 Comfort Seat Kits at CHG 001, the DSI-9508-011 Rivet Kit is available from Dart:

QTY	Part Number	Description
-011		
X	DSI-9508-011	Rivet Kit
8	BSP-42	Rivet
16	NAS1149DN616J	Washer (or AN960JD6L)

CANADA	
DEPARTMENT OF TRANSPORT	
AIRCRAFT CERTIFICATION	
BRANCH	
DAO # 01-O-01	
APPROVED	
BY:	
D. SHEPHERD (DE # 02)	
DATE:	10.03.02
CERT. NO.:	SH08-37
ISSUE NO.:	1

A	NEW ISSUE	CP	10.03.02
REV.	DESCRIPTION	BY	DATE
DESIGN	9P	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	9P		
CHECKED	13		
MFG. APPR.	N/A		
APPROVED	44		
DE APPR.	44	TITLE	SCALE
DATE	10.03.02	RIVET KIT	
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